

Work Order ID 70624

Monday, June 13, 2011 12:47:06 PM



Page 1

Item ID: D3575-6

Accept



Setup Start



Revision ID:

Stop



Item Name: Cabin Floor Protector

Start Date: 6/10/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 6-13

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3575	Rev A								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3575 ☒ Dwg Rev: ☐ Prog Rev: ☐ 2-
Debur if necessary

B11-6-14

(2)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-6-14

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Small Fab	Small Fab	0.00							
Small Fab	Memo	0.00	SB	1160614		(2)			
Small Fab	Deburr if necessary.								
140 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00	8	1160614		(42)			
150 Packaging	Identify as per dwg & Stock Location: _____	0.00							
Packaging	Memo	0.00	PM70618						

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Setup Start



Revision ID:

Stop



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Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/15

ME

11-06-14

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Monday, June 13, 2011 12:47:12 PM

Page 1

Work Order ID: 70624



Parent Item: D3575-6



Parent Item Name: Cabin Floor Protector

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev :A New Issue 07.07.23 EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	1,758.215	10.666	22.45474			
GE PLASTICS LEXAN SHEET													

1811-6-14

Location

Loc Qty

Loc Code

MAT018

1758.215789

116236

1758.21579

116236

(2)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 70624
Description: Cabin Floor Protector		Part Number: D3575-6
Inspection Dwg: D3575	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.004	X		VHBD 2	
3.38	+/-0.030	3.38	X		THD	
6.50	+/-0.030	6.50	Ø		T	
26.13	+/-0.030	26.13	Ø		T	
30.13	+/-0.030	30.13	Ø		T	
2.00	+/-0.030	2.00	Ø		T	
3.50	+/-0.030	3.50	Ø		T	
14.25	+/-0.030	14.25	Ø		T	
25.13	+/-0.030	25.13	Ø		T	
29.38	+/-0.030	29.38	Ø		T	
30.38	+/-0.030	30.38	Ø		T	
31.50	+/-0.030	31.50	Ø		T	
1.00	+/-0.030	1.00	Ø		T	
4.38	+/-0.030	4.38	Ø		T	
14.50	+/-0.030	14.50	Ø		T	
16.00	+/-0.030	16.00	Ø		T	
23.13	+/-0.030	23.13	Ø		T	
26.88	+/-0.030	26.88	Ø		T	
27.69	+/-0.030	27.69	Ø		T	
1.00	+/-0.030	1.00	Ø		T	
3.75	+/-0.030	3.75	Ø		T	
9.63	+/-0.030	9.63	Ø		T	
16.13	+/-0.030	16.13	Ø		T	
28.06	+/-0.030	28.06	Ø		T	
32.15	+/-0.030	32.15	Ø		T	

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 11-6-14	Date: 11/6/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/DD	

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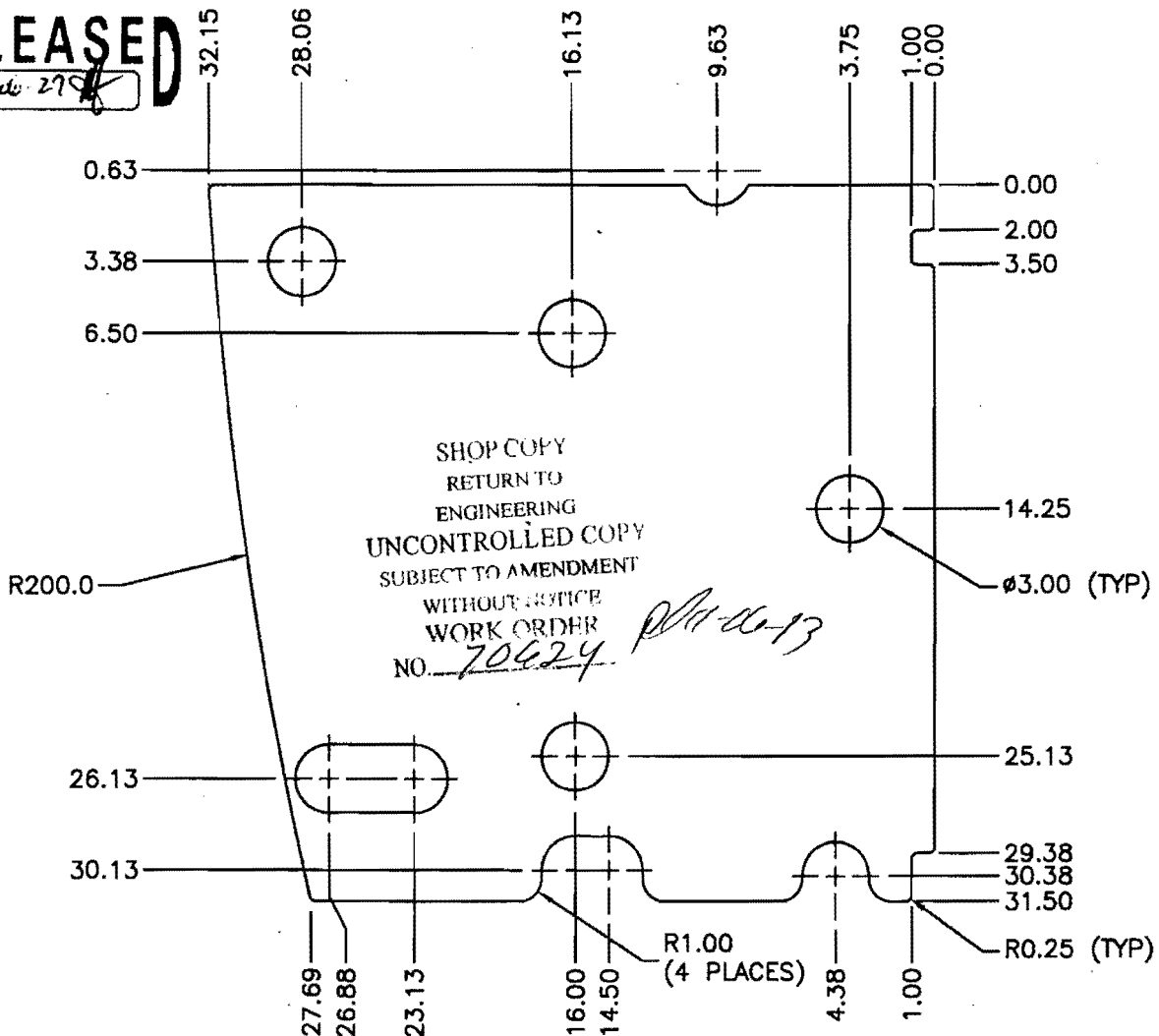
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DART

DESIGN <i>LE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3575	REV. A SHEET 4 OF 4
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:8

RELEASED
07-06-2008

D3575-5 CABIN FLOOR PROTECTOR (SHOWN)
D3575-6 CABIN FLOOR PROTECTOR (OPPOSITE)

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-5/-6" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8969

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